

5/14

DART AEROSPACE LTD	Work Order:	22761
Description: Console Side LH (206 Hi-Slope)	Part Number:	D2602-1
Note: Issue with Part Number D2602-2		
Dwg: D2602 Rev. A1	Qty:	17 20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	EP	05.03.17	20
2	MV	Cut Blank per template DT8243 Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>M16548</u> <u>M16241</u> <u>M16302</u>	EP	05/04/05	20
3	MV	Machine as per Folio FA145 and Dwg D2602 Stack of 10 Identify as D2602-1	EP	05/04/06	20 Pto
4	QC2	Inspect parts as they come off the CNC machine	EP	05/04/06	20
5	QC8	Second check	EP	05/04/07	20
6	GA	Deburr	SB	05/04/11	19 PTO
7	GB	Form as per Dwg D2602	SB	05/04/12	17
8	QC5	Inspect work to Step 7	EP	05/04/15	17
9	FP	Acid etch and Alodine as per QSI.005 4.1	ML	05-04-15	17
10	QC3	Inspect work to Step 9	ML	05/04/15	17
11	ST	Identify and Stock	ML	05-04-15	17
12	AC	Cost / part <u>18.74</u>	SAC	05-04-19	17
13	DC	Close W/O <u>18.28</u> Inspect Level 21	EP	05.04.26	17

Rev	Date	Change	Revised By	Approved
A	96.07.27	New Issue		
B	98.05.08	Added drawing revision	KB	
C	98.11.25	Added Inspection Levels	DM	
D	04.02.25	Reformat	KJ/RF	

RELEASED

05/04/05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 22761		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
02.06.04	3	0.838" DIMENSION UNDER TOLERANCE ON SOME PARTS BY UP TO 0.030"	CP	WHEN BENDING? PAIR-UP SIMILAR PARTS & MAINTAIN 0.674" FLANGE DIMENSION.	SB 05/01/18 SB	05/01/18	per asst	05/01/18
05/04/12	7	1 part was scrap Bend over tolerance	18 per asst	destroy	SB 05/04/13	05/04/13	per asst	05/04/13
05/04/12								

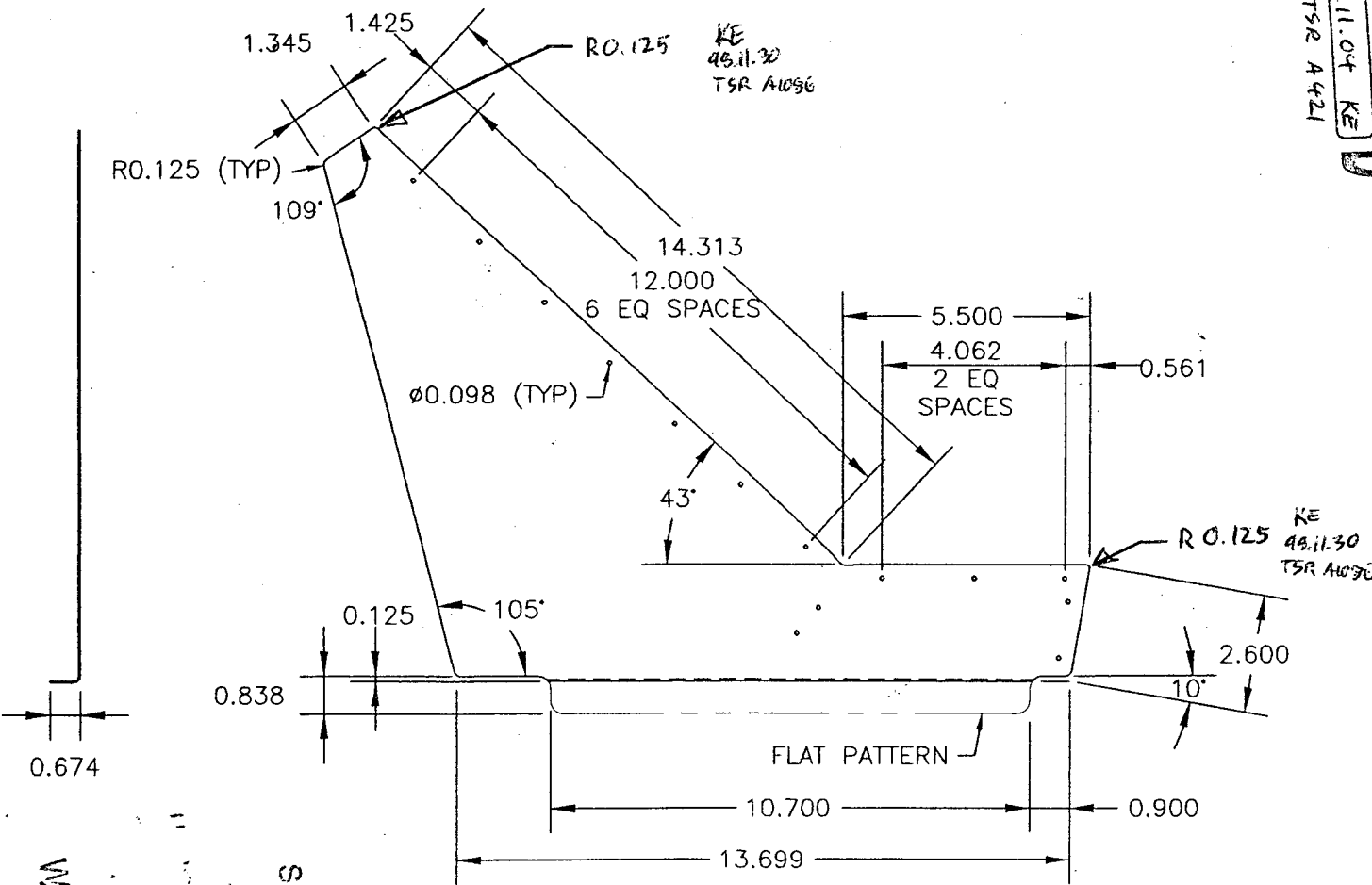
Part No: D2602-1 PAR #: _____ Fault Category: Production / Fin ^{machining} NCR: Yes ~~No~~ DQA: CP Date: 05/04/20
 NOTE: Date & initial all entries QA: N/C Closed: KJ Date: 05.04.26

DART



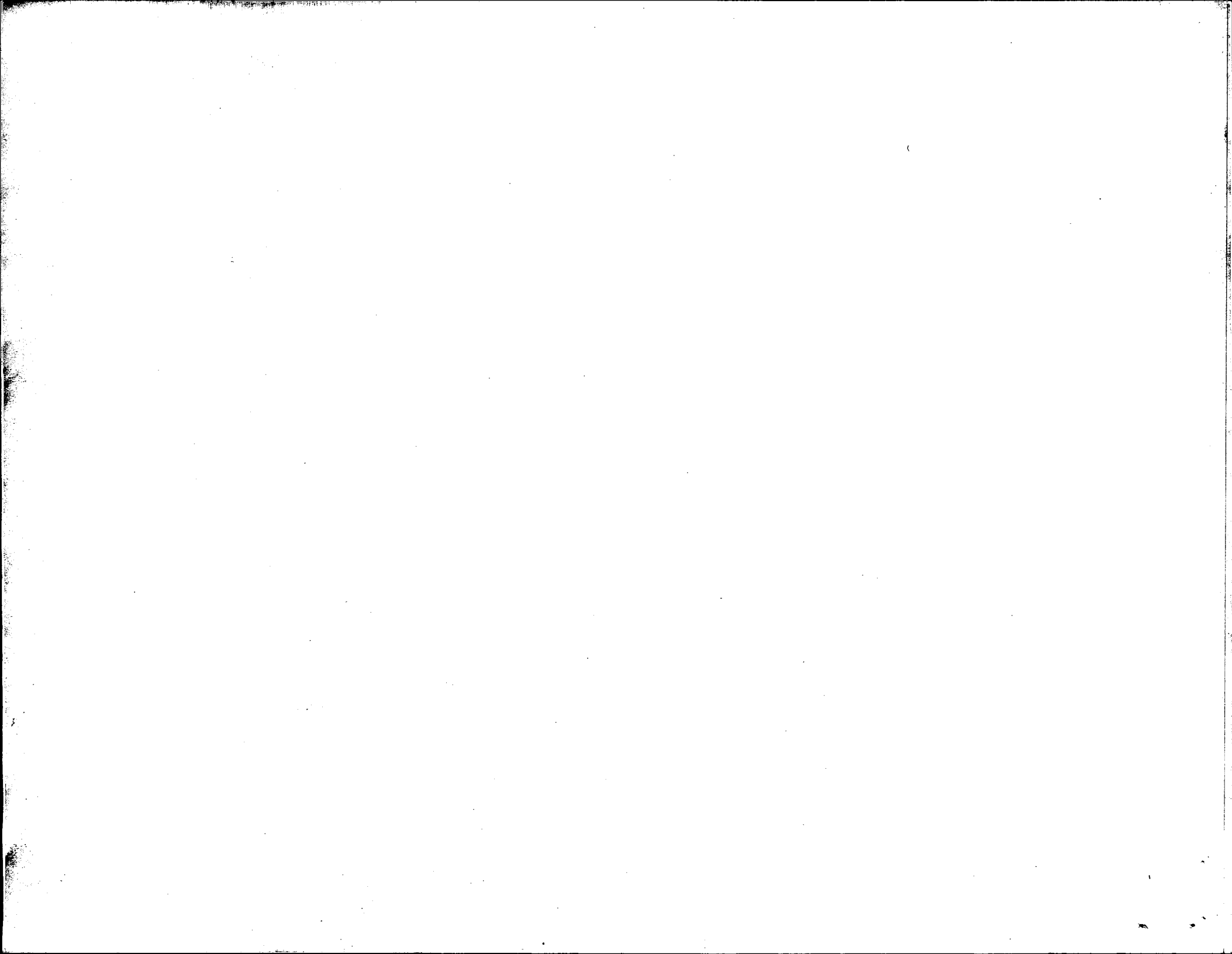
RELEASED
97.11.04 KE
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED KE	APPROVED Bm	DRAWING NO. D2602	REV. A
DATE 97.10.22		TITLE CONSOLE SIDE	SHEET 1 OF 1
			SCALE 1:4
A	97.10.22	D2602 WAS D206-547-21/-22	
AI	32.06.04	ADD FINISH	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
 PROFILE CONTROLLED BY FOLIO H2602
 BEND RADIUS 0.093
 FINISH: CHEMICAL CONVERSION COAT PER DART QSL 005 4.1 **AI**
 D2602-1 SHOWN
 D2602-2 OPPOSITE

WORK ORDER
 NO. 22761
 SHIP TO
 DART AEROSPACE LTD
 VICTORIA INTERNATIONAL AIRPORT
 VICTORIA, BC
 CANADA
 11/11/97 COPY



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 17, 2005
02:16 pm

Work Order No : 0022761
Project Name : D2602-1
Project For : WK514
Work Order Type : Main
Main WO Number :
House Part Number : D2602-1
Description : Console Side Hi Slope
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 03-17-05
Est Finish Date : 04-07-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Chris Provencal

From: "David Shepherd" <davids@dartaero.com>
To: "Chris Provencal" <chrisp@dartaero.com>
Cc: "Bill Beckett" <billb@dartaero.com>
Sent: April 7, 2005 1:52 PM
Subject: Your console problem

Chris,

The easy decision for Engineering is to scrap these parts. That way, there will be no problems down the line. I would discuss with Bill as he will know the value much better than me.

Having said that, I believe you and I agree that the parts could be salvaged (if this is more cost effective) by bending them in pairs (one left and one right) and preserving the width of the tab as much as possible (reduce console height slightly, but left MUST match right).

If you decide to salvage, you can use this email as my acceptance of the deviation and attach to WO.

The big question is what happened. Looks like something shifted or lifted up on the HAAS to me.

David

07/04/2005